

Title (en)

Method for extrusion blow moulding hollow bodies of thermoplastic material

Title (de)

Verfahren zum Extrusionsblasformen von Hohlkörpern aus thermoplastischem Kunststoff

Title (fr)

Procédé de moulage de corps creux en matière thermoplastique par extrusion soufflage

Publication

EP 0693357 B1 20011004 (DE)

Application

EP 95109413 A 19950619

Priority

DE 4421171 A 19940620

Abstract (en)

[origin: EP0693357A2] The thermoplastic extruder's (2) orifice (4) is controlled by the wall thickness program (3). The preform (1) is blown to a hollow body (7) in the mould (6), removed, and any adherent fragments are taken out. The time t1st to extrude a given length, is measured; difference at DELTA G from the desired value Gsoll; this is stored, paired with DELTA t values. The pairs control ns and sa in a following cycle. It measures the time to grow the preform, even before it is blown to shape. This is largely controlled by the extrusion gap and extruder screw speed, for given material properties. The weight of the vessel, the material distribution in the hollow blown body, and the wall thickness are controlled. The process in this case produces a particularly marked stretching of the preform, a rectangular vessel being depicted. The parameters are particularly quickly stabilised. Any weight variation is fed back to the next cycle. All the key process parameters are inter-related to the programmed wall thickness. Because the parameters are inter-related, methods relying on individual adjustment and measuring the effects in isolation are obviated. Further process details are provided, and examples of the necessary corrective action, in terms of screw speed alteration, required by measured extrusion times, are tabulated for a practical case. <IMAGE>

IPC 1-7

B29C 49/04; **B29C 49/78**; **B29C 47/92**

IPC 8 full level

B29C 48/92 (2019.01); **B29C 49/00** (2006.01); **B29C 49/04** (2006.01); **B29C 49/78** (2006.01)

CPC (source: EP US)

B29C 48/09 (2019.02 - EP); **B29C 48/92** (2019.02 - EP); **B29C 49/0411** (2022.05 - US); **B29C 49/071** (2022.05 - EP); **B29C 49/78** (2013.01 - EP US); **B29C 49/04** (2013.01 - EP); **B29C 2049/787** (2022.05 - US); **B29C 2049/7874** (2022.05 - EP); **B29C 2948/92066** (2019.02 - EP); **B29C 2948/92142** (2019.02 - EP); **B29C 2948/92428** (2019.02 - EP); **B29C 2948/9259** (2019.02 - EP); **B29C 2948/92647** (2019.02 - EP); **B29C 2948/92885** (2019.02 - EP); **B29C 2948/92904** (2019.02 - EP); **B29C 2948/92923** (2019.02 - EP)

Cited by

DE102008052609A1; DE102008052608B3; DE102008052611B3; DE102008052609B4; WO2009053418A1; WO2009003662A3

Designated contracting state (EPC)

AT BE CH DE ES FR GB IE IT LI NL

DOCDB simple family (publication)

EP 0693357 A2 19960124; **EP 0693357 A3 19980429**; **EP 0693357 B1 20011004**; AT E206350 T1 20011015; DE 4421171 C1 19960104; DE 59509654 D1 20011108

DOCDB simple family (application)

EP 95109413 A 19950619; AT 95109413 T 19950619; DE 4421171 A 19940620; DE 59509654 T 19950619